


NOTICE: THE INFORMATION AND DESIGN CONTAINED HEREIN IS THE PROPERTY OF PREMIER AVIATION WHO RESERVES ALL RIGHTS THERETO

NOTES (UNLESS OTHERWISE SPECIFIED):

1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112 LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
 2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01 - .03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
 3. UNLESS OTHERWISE SPECIFIED, CHEM FILM (ALODINE) ALUMINUM DETAIL PARTS PER PREMIER SPECIFICATION 008-93003.
 4. GENERAL SHOP PRACTICES PER AC43.13-1A/-2A. COMPOSITE STRUCTURE SHOP PRACTICES PER PREMIER SPECIFICATION 008-93001.
-  MAKE PARTS PER TEMPLATE/MOLD. SEE CHART BELOW. TOOL IS TO BE MARKED WITH PART # AND A "T" AT THE END.
EXAMPLE: BXX-XXXX-XX"T"

PART #	TOOL #	PART #	TOOL #	PART #	TOOL #	PART #	TOOL #
-01	-01T	-08	-08T	-63	-63T	-63	-63T
-02	-02T	-19	-19T	-69	-69T	-69	-69T
-03	-03T	-20	-20T	-71	-71T	-71	-71T
-04	-04T	-23	-23T	-73	-73T	-73	-73T
-05	-05T	-24	-24T	-75	-75T	-75	-75T
-06	-06T	-59	-59T	-77	-77T	-77	-77T
-07	-07T	-61	-61T	-79	-79T	-79	-79T

PART #	TOOL #	PART #	TOOL #	PART #	TOOL #	PART #	TOOL #
-191	-191T	-206	-206T	-137	-137T	-137	-137T
-193	-193T			-139	-139T	-139	-139T
-195	-195T	-211	-211T	-235	-235T	-235	-235T
-197	-197T	-219	-219T	-243	-243T	-243	-243T
-199	-199T	-220	-220T	-244	-244T	-244	-244T
-203	-203T	-65	-65T				
-205	-205T	-67	-67T				

6. COAT WITH NEDOX FM-5, MIL-C-26074
7. FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL -147 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
8. INSTALL DOOR/WINDOWS PER BELL'S 412 MAINTENANCE MANUAL CHAPTER 52, SECTIONS 52-20-3, AND 52-20-5 EXCEPT ITEMS 7 & 8 AND 52-50-7A.
9. WELD PER MIL-STD-2219.
10. ALTERNATE: 2664-1 HANDLE ASSY (BELL).
11. ALTERNATE P/N 70-027-1 BELL, OR 034-23002-01 PREMIER.
12. CADMIUM PLATE PER QQ-P-416F, CLASS 2, TYPE 2.
13. ALL WINDOWS MUST POP OUT AT 35 TO 55 lbs. AT EXIT PLACARDS.
14. DECALS TO BE LOCATED AS STATED & APPROX AS SHOWN.

EMERGENCY
PUSH HERE

DECAL(212-072-635-101) 16 PLACES. LOCATE
INSIDE AND OUTSIDE CORNERS 0.1 TO 0.4 INCH FROM
RETAINER OF EACH PASSENGER WINDOE.

REVISIONS			
REV		DATE	APPROVE
-	MFG. RELEASE	1.27.93	GM
A	REVISED PER ECO NO. 3727	7.14.93	PHL
B	REVISED PER ECO NO. 3767	9/2/93	PHL
C	REVISED PER ECO NO. 4104	4/20/94	MRC
D	REVISED PER ECO NO. 4345	11/04/94	NLS
E	REVISED PER ECO NO. 4533	05/02/95	NLS
F	REVISED PER ECO NO. 5662	10/16/98	KS

QTY	DESCRIPTION	SPECIFICATION	CODE IDENT NO.
1	HANDLE WELDMENT		
1	BRKT. MOD (OPP. -37)	M/F B32-23001-04	
1	BRKT MOD	M/F B32-23001-03	
1	BRKT MOD (OPP. -35)	M/F B32-23001-06	
1	BRKT MOD	M/F B32-23001-05	
2	BRKT MOD	M/F B32-23001-01	
1	COVER ASSY (OPP -24)		
1	COVER ASSY		
1	HINGE WELDMENT (OPP. -27)		
1	HINGE WELDMENT		
1	HINGE WELDMENT		
1	WINDOW MOD. (OPP.)		
1	WINDOW MOD.		
1	ROD WELDMENT (OPP.)		
1	ROD WELDMENT		
1	COVER ASSY (OPP -19)		
1	COVER ASSY		
2	GUIDE ASSY		
1	PLATE ASSY		
1	ROD WELDMENT (OPP. -13)		
1	ROD WELDMENT		
1	BRKT ASSY (OPP -11)		
1	BRKT ASSY		
1	DOUBLER ASSY (OPP -09)		
1	DOUBLER ASSY		
1	KLEGECELL ASSY (OPP -07)		
1	KLEGECELL ASSY		
1	KLEGECELL ASSY (OPP -05)		
1	KLEGECELL ASSY		
1	DOOR ASSY (OPP -03)		
1	DOOR ASSY		
1	DOOR ASSY (OPP -01)		
1	DOOR ASSY		

ECO

6063

6097

6339

6803

7052

PARTS LIST

ECO
6063
6097
6339
6803
7052

MATERIAL	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON		DRAWN	L. CELESTINO	DATE	11/2/92	PREMIER AVIATION, INC	
	DECIMALS	.XX±.05 .XXX±.03	CHECKED				2621 Aviation Parkway, Grand Prairie, Texas 75052	
FINISH LAST SECTION LETTER USED "PP"	ANGLES	±1°	APPROVAL				EXTENDED UTILITY DOOR DETAILS/ASSY	
	ON	NHA	APPROVAL					
	412		RELEASED	gm		1/27/93	SIZE CODE IDENT NO.	
	212		APPROVAL				D 0SUVR B30-23000	
	412EP		APPROVAL				REV F	
			APPROVAL				SCALE: 1/1	
							SHEET 1 OF 2	

STC'd PRINT B3023000.01


ORIGINAL

MS 5698 HCSH 8625W

NOTES: Cont.

↑ **EMERGENCY EXIT** ↑
PUSH WINDOW AT LOWER CORNER

DECAL (212-072-637-109) 4 PLACES.
LOCATE OUTSIDE CENTERED BELOW EACH
PASSENGER WINDOW.

DECAL (31-072-1) 2 PLACES.
LOCATE INSIDE LEFT AND RIGHT
PASSENGER DOOR WINDOWS. 

DECAL (31-057-4EH)-2 PLACE. LOCATE
INSIDE UNDER END OF RIGHT PASSENGER
DOOR HANDLE.

DECAL (31-057-3EH)-2 PLACE. LOCATE
INSIDE UNDER END OF LEFT PASSENGER
DOOR HANDLE.

OPEN


DECAL (31-042-7BHF)-4 PLACES. LOCATE
INSIDE UNDER SHAFT OF PASSENGER DOOR
HANDLES.

LOCKED

DECAL (31-042-13DHF)-4 PLACES. LOCATE
INSIDE ABOVE END OF BOTH PASSENGER
DOOR HANDLES.

 ROLLER BRKT'S TO BE SHIMMED AS REQD AT INSTALLATION
USING AN960 NUMBER 10 (TEN) WASHERS INSTEAD OF PEEL
SHIM AS STATED IN BELL MAINTENANCE MANUAL CHAPTER 52.

 INSTALL & ADJUST DOORS I.A.W. PREMIER B04-73001
RIGGING & ADJUSTMENT PROCEDURE.

 OPEN

 PASSIVATE CORROSION RESISTANT STEEL PARTS I.A.W. QQ-P-35C.

19. REMOVED.
















20. REMOVED.

21. REMOVED.

 ALTERNATE: USE MS20392-1C11 PIN.

 ALTERNATE: USE PREMIER 083-81000-25 PLACARD.

NOTES CONTINUED ON SHEET 3 ZONE 8D.

PART NO.		DESCRIPTION		SPECIFICATION		CODE IDENT NO.		ITEM NO.	
-139		ROD		M/F: .25 OD. X. .049 WALL 304 S.S. TUBING					
-137		ROD		M/F: .25 OD. X. .049 WALL 304 S.S. TUBING					
-135		OPEN							
-133		LEVER		M/F: .071 THK. 4130 STEEL MIL-S-18729					
-131		PLATE		M/F: .250 THK. ALUM 2024-T3, QQ-A-250/4					
-129		BAR		M/F: .500 DIA ROD 6061-T6, QQ-A-200/8					
-127		PLATE		M/F: .125 THK ALUM 6061-T6, QQ-A-250/11					
-125		PIN		M/F: 3/8 DIA BAR 17-4 S.S.					
-123		OPEN							
-121		EYE BOLT		AN4 EA EYE BOLT					
-119		PIN		M/F: .250 DIA ROD 4130 MIL-S-6758					
-117		LEVER		M/F: .090 THK. 4130 STEEL MIL-S-18729					
-115		ROLLER		M/F: NYLATRON MBS 1.5" O.D. ROD					
-113		CLEVIS		M/F: .750 DIA ROD 4130 STEEL					
-111		WASHER		M/F: .75 DIA 17-4 STAINLESS STEEL					
-110		BRKT (OPP.-109)		M/F: 1.25 THK. 17-4 STAINLESS STEEL					
-109		BRKT		M/F: 1.25 THK. 17-4 STAINLESS STEEL					
-107		LEVER		M/F: .090 THK. 4130 STEEL MIL-S-18729					
-106		BRKT (OPP.-105)		M/F: 1.25 THK. 17-4 STAINLESS STEEL					
-105		BRKT		M/F: 1.25 THK. 17-4 STAINLESS STEEL					
-103		LEVER		M/F: .090 THK. 4130 STEEL MIL-S-18729					
-101		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-99		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-98		DOUBLER (OPP.-97)		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-97		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-95		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-93		BRKT		M/F: .090 THK. 4130 STEEL MIL-S-18729					
-92		DOUBLER (OPP.-91)		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-91		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-89		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-87		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-85		ANGLE		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-83		ANGLE		M/F: AND10133-1001 2024-T3511, QQ-A-200/3					
-81		ANGLE		M/F: AND10133-1001 2024-T3511, QQ-A-200/3					
-79		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-77		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-75		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-73		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-71		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-69		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-67		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-65		DOUBLER		M/F: .032 THK. ALUM 2024-T3, QQ-A-250/4					
-63		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-61		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-59		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					
-57		PAD		M/F: POLIEX TR75 1" THK. 5lbs. KLECELL					

PARTS LIST

SIZE CODE IDENT NO. **D OSUV8 B30-23000** REV. **F**
EXTENDED UTILITY DOOR ASSY/INSTALL SHEET 2 OF 26

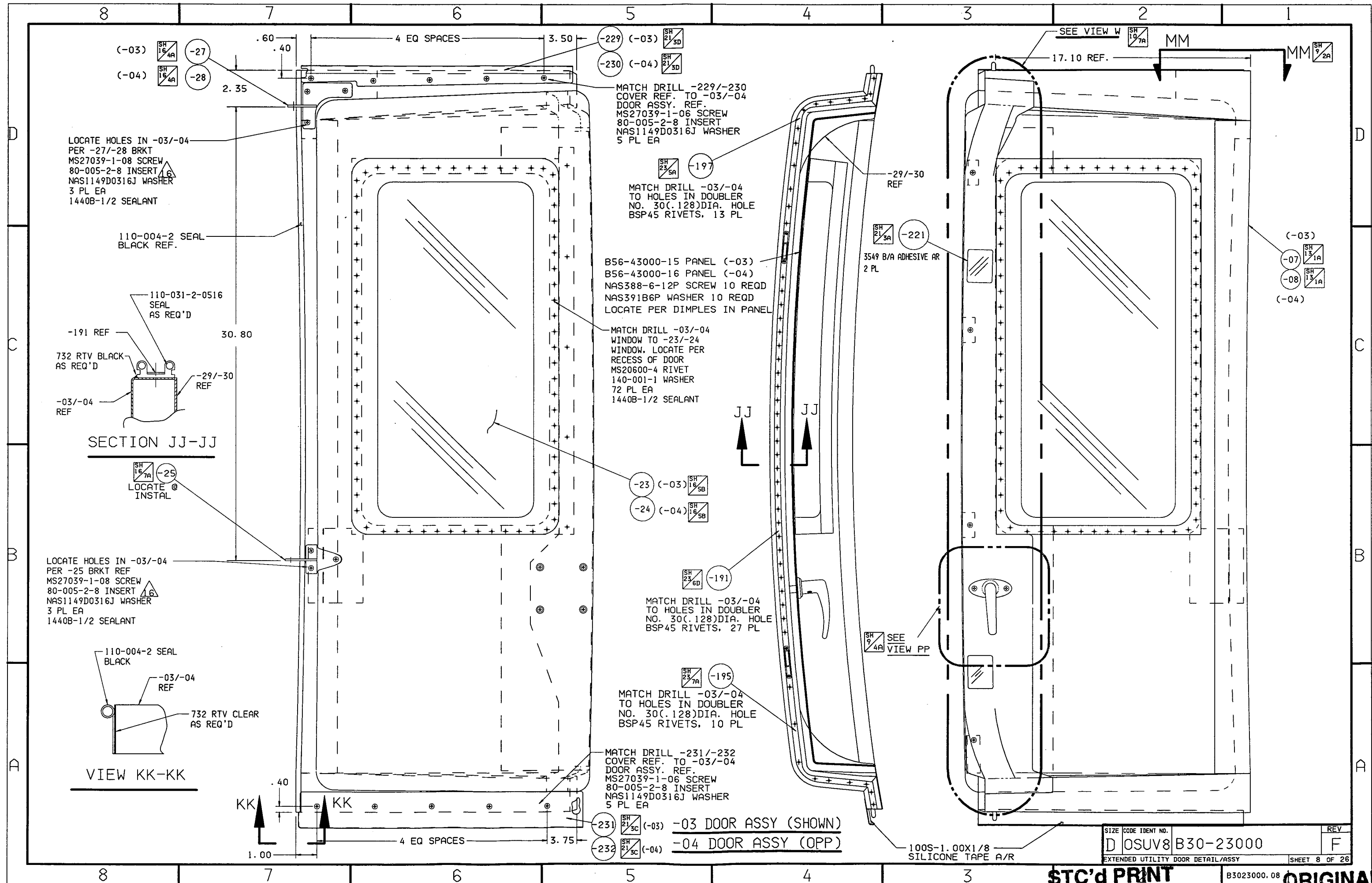
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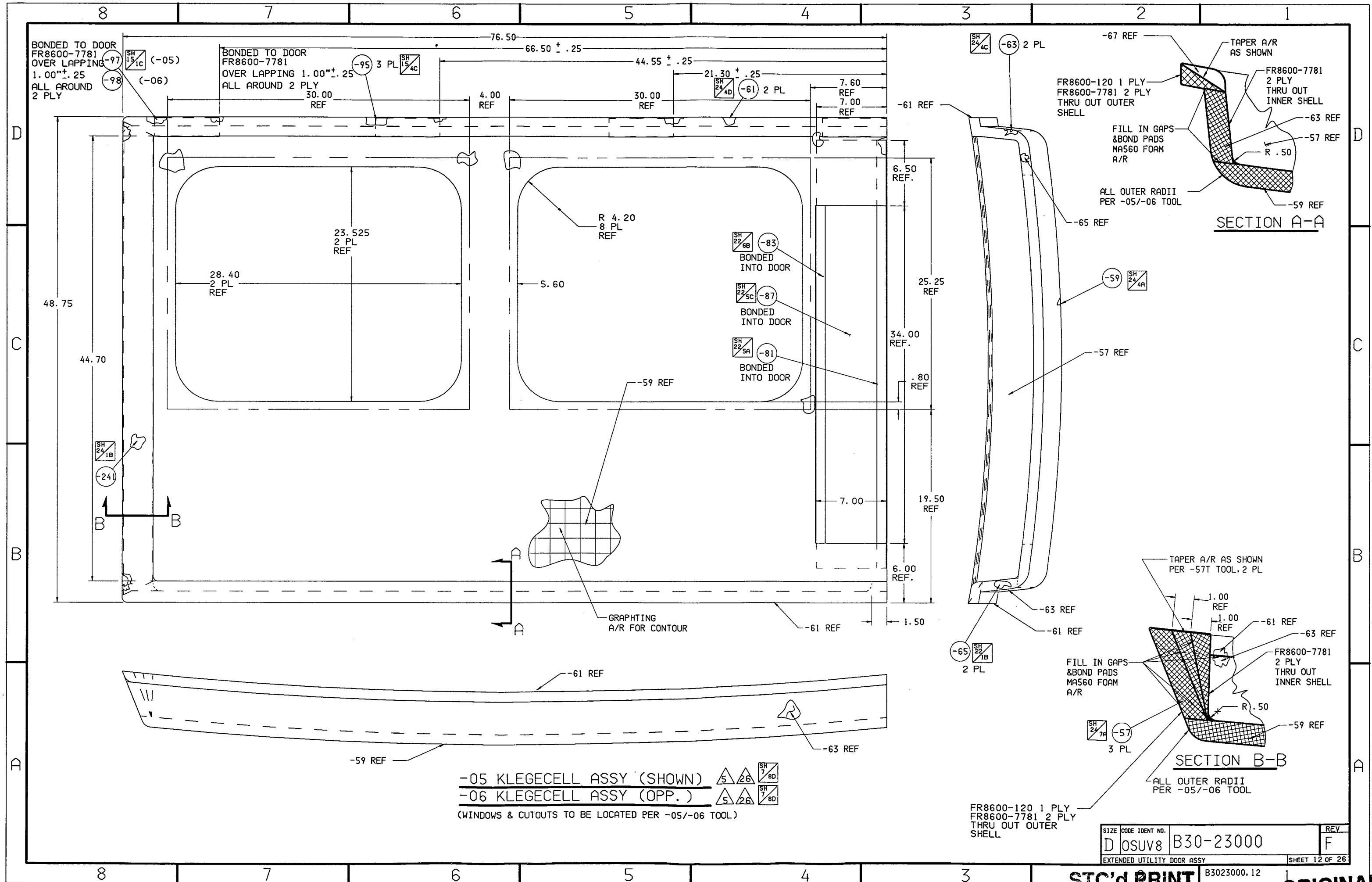
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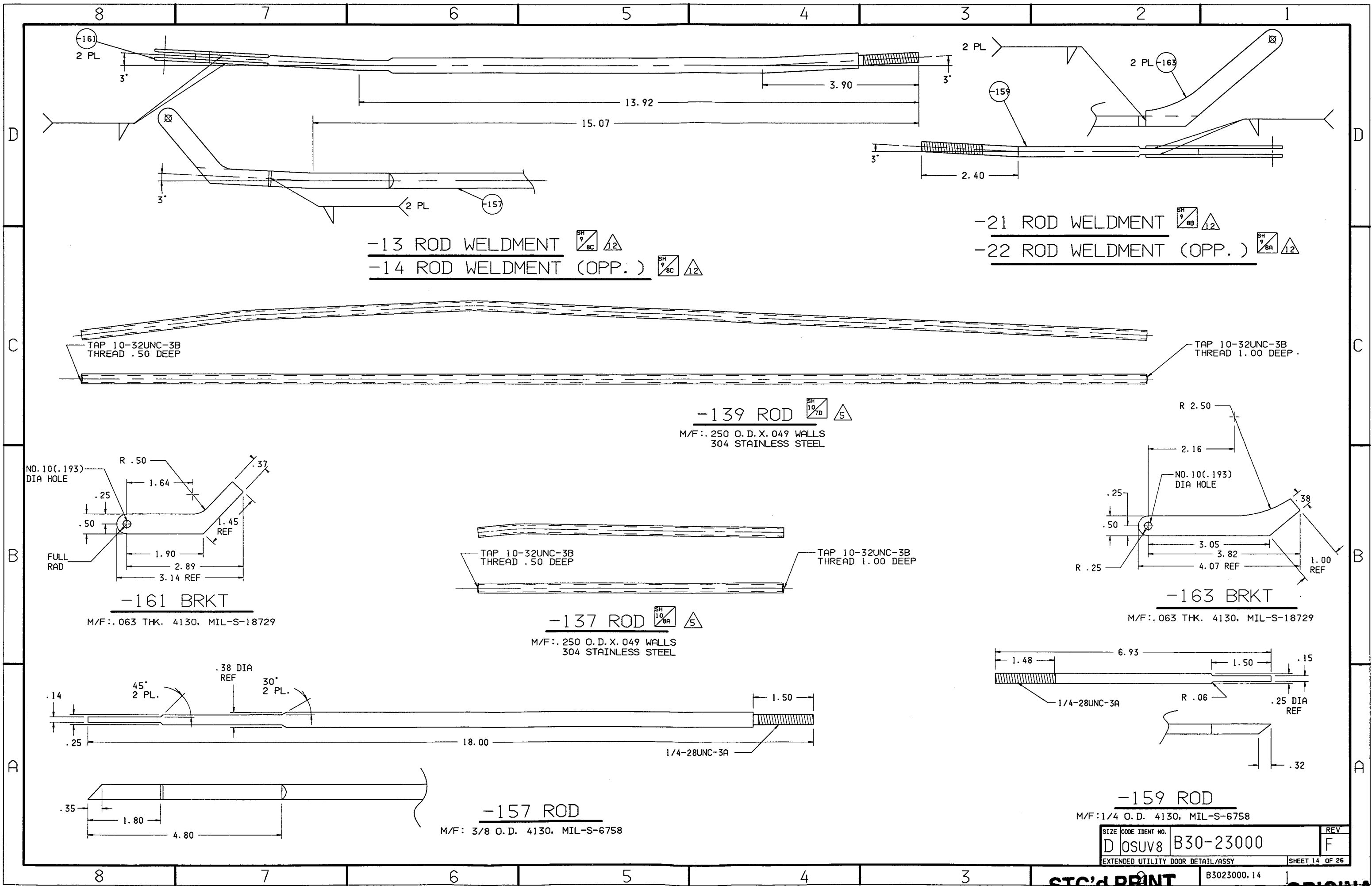
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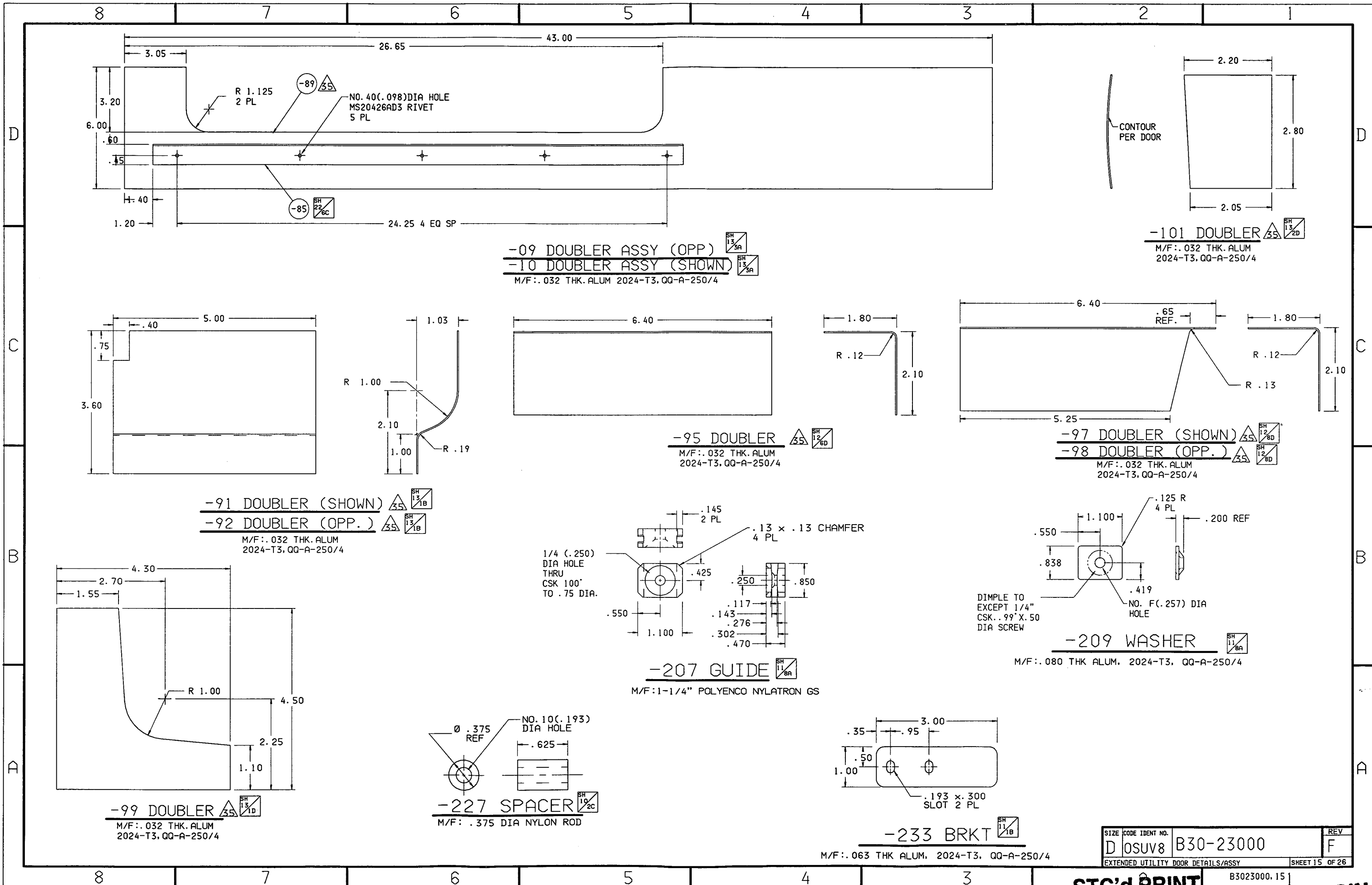




SIZE	CODE	IDENT NO.	REV
D	OSUV8	B30-23000	F
EXTENDED UTILITY DOOR DETAIL/ASSY			SHEET 14 OF 26

B3023000, 14

STC SH 8625 SW

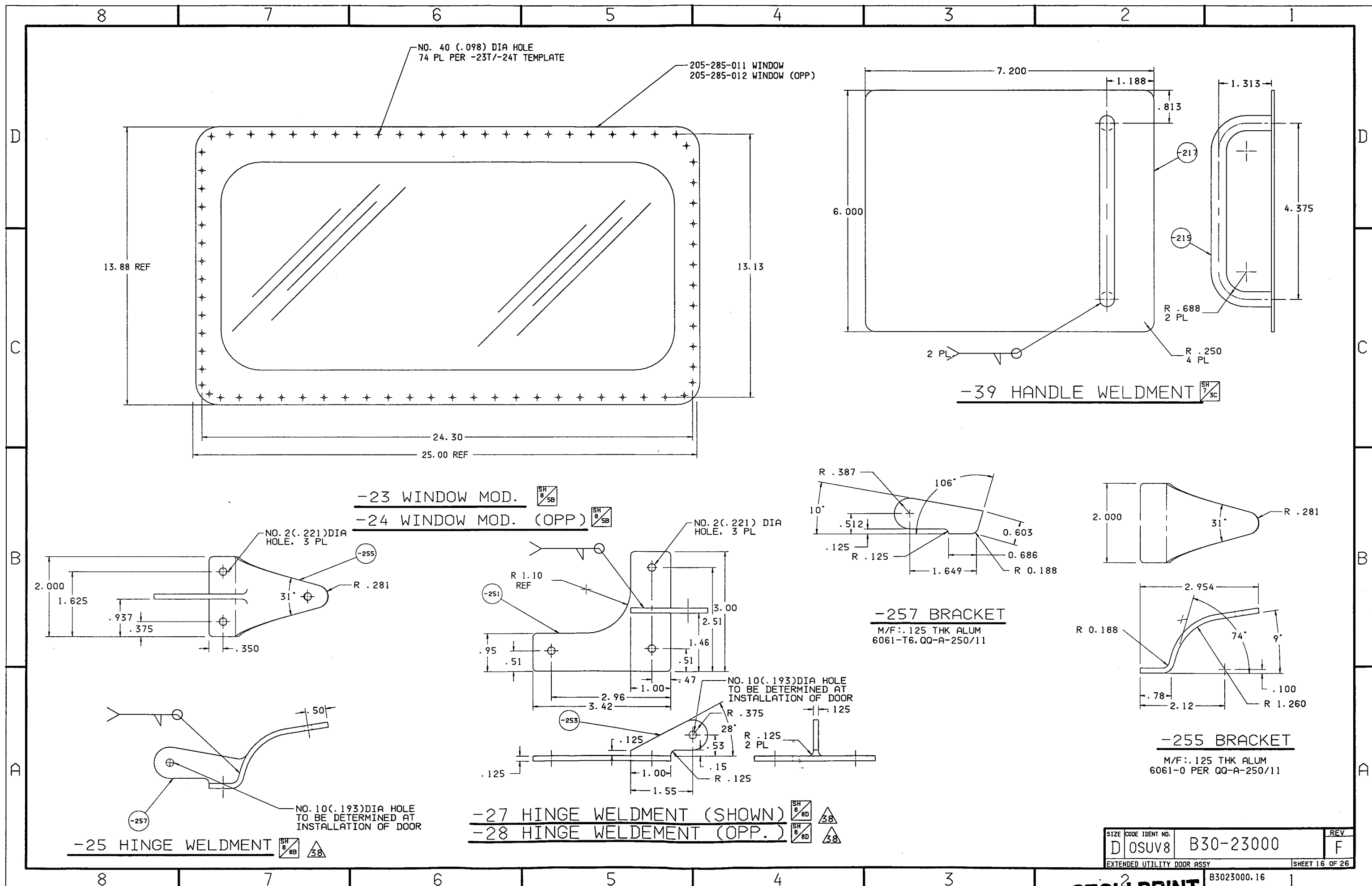


STC'd PRINT

B3023000.151

ORIGINAL

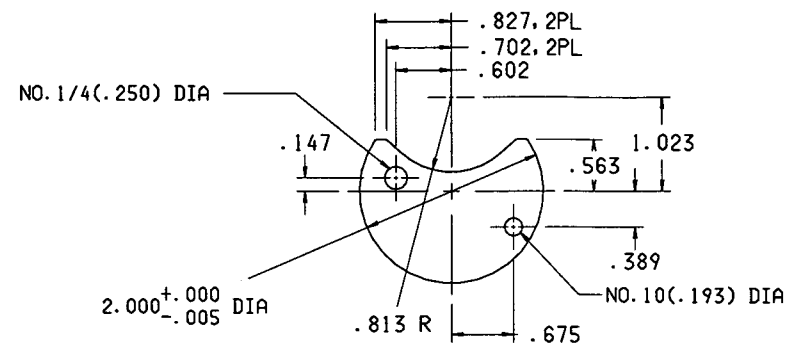
STCSH 8 6 25 SW




STCSH8625\$W

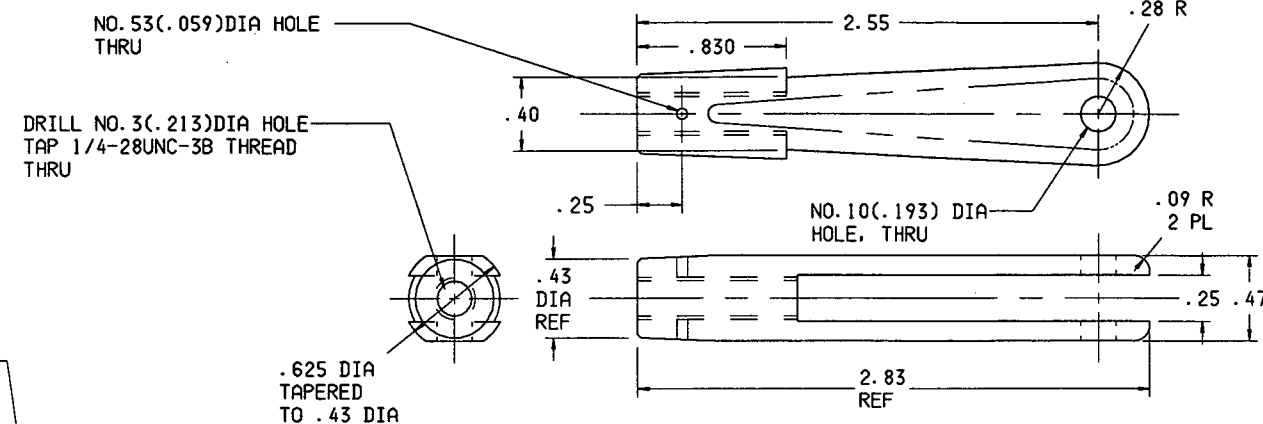
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ORIGINAL

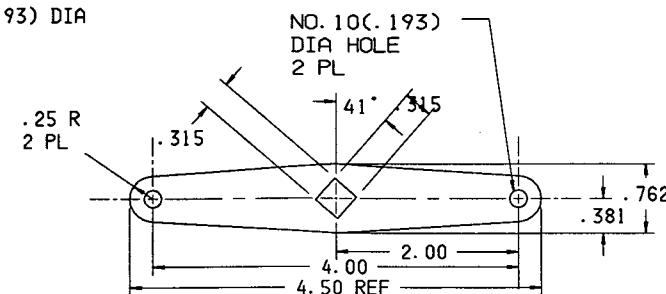


-149 CAM 
MAT'L: .250⁺_{-.003} THK, 304 SS

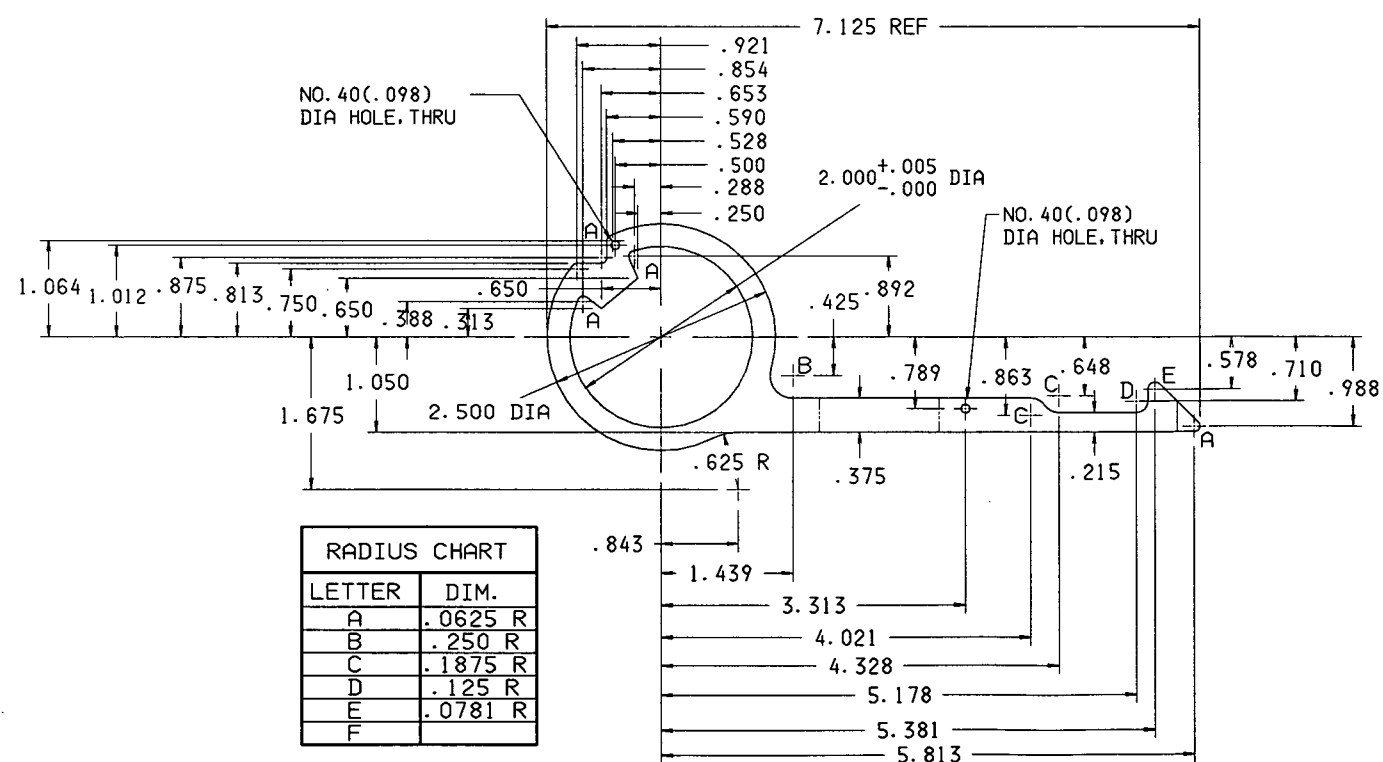
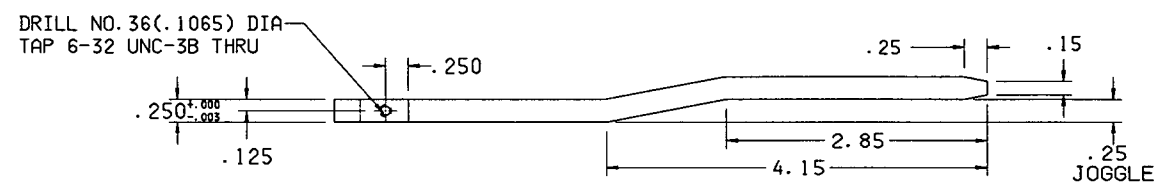
M/F :. 75 DIA ROD 303 S.S.



(SCALE:2/1)
M/F:11/16 THK 4130 MIL-S-6758



M/F: .125 THK. 304 STEEL

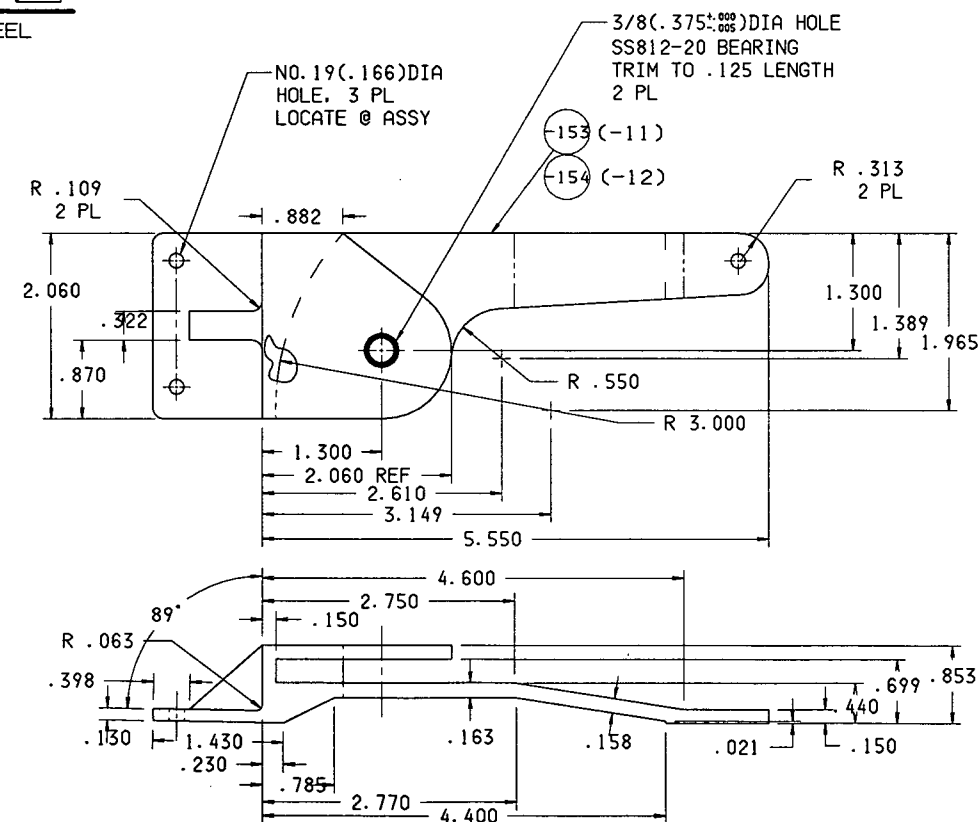


RADIUS CHART	
LETTER	DIM.
A	.0625 R
B	.250 R
C	.1875 R
D	.125 R
E	.0781 R
F	

-148 HOOK (OPP.) SH
9
6D 17 18

M/F: .250 THK 304 STAINLESS STEEL

● MACHINED DIMENSIONS TO BE MET BEFORE PART IS JOGGLED



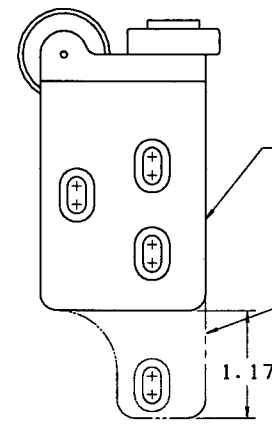
-12 BRKT ASSY (OPP)

SIZE	CODE IDENT NO.		REV
D	OSUV8	B30-23000	F
EXTENDED UTILITY DOOR DETAILS/ASSY			SHEET 17 OF 26

B3023000, 17

ORIGINAL

MS 5298 HSJLS

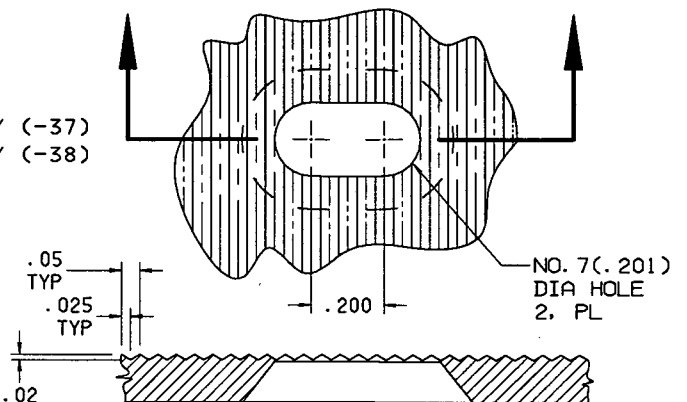


M/F B32-23001-03 BRACKET ASSY (-37)
M/F B32-23001-04 BRACKET ASSY (-38)

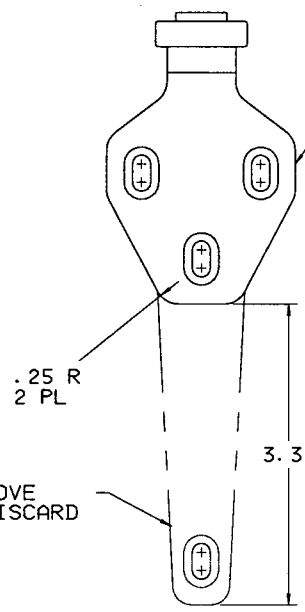
REMOVE
& DISCARD

1.17

-37 BRKT MOD(SHOWN)
-38 BRKT MOD(OPP)



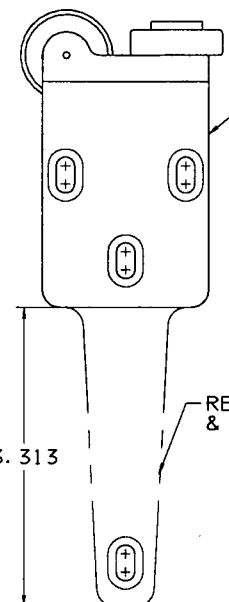
VIEW F-F
(SCALE: 4/1)



M/F B32-23001-01
BRACKET ASSY

REMOVE
& DISCARD

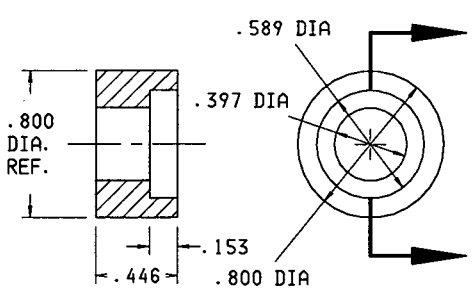
-33 BRKT MOD



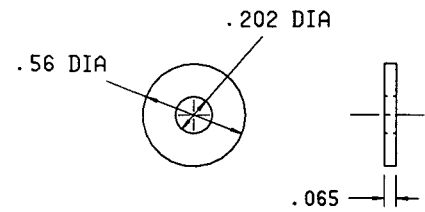
M/F B32-23001-05 BRACKET ASSY (-35)
M/F B32-23001-06 BRACKET ASSY (-36)

REMOVE
& DISCARD

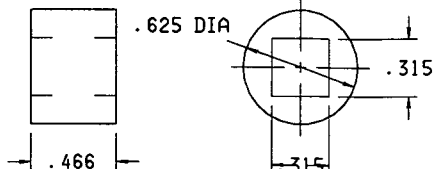
-35 BRKT MOD (SHOWN)
-36 BRKT MOD (OPP.)



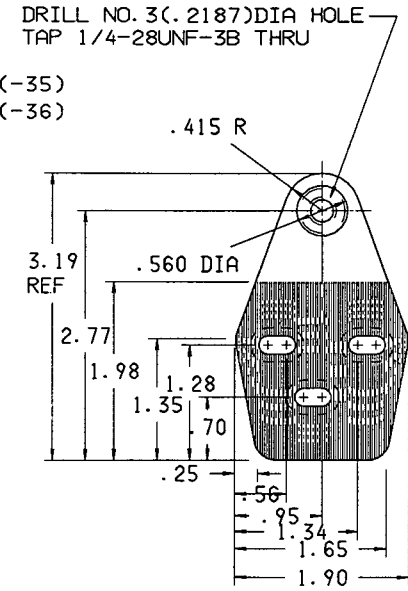
-115 ROLLER
(SCALE: 2/1)
M/F: NYLATRON NBS
1.5" O.D. ROD



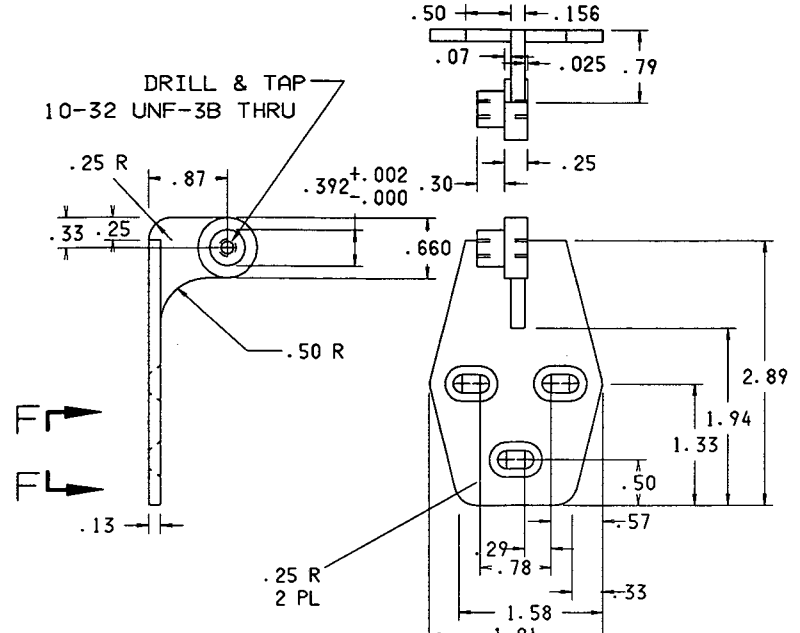
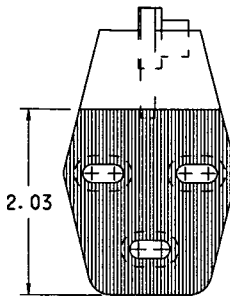
-111 WASHER
(SCALE: 2/1)
M/F: .75 DIA ROD
17-4 STAINLESS STEEL



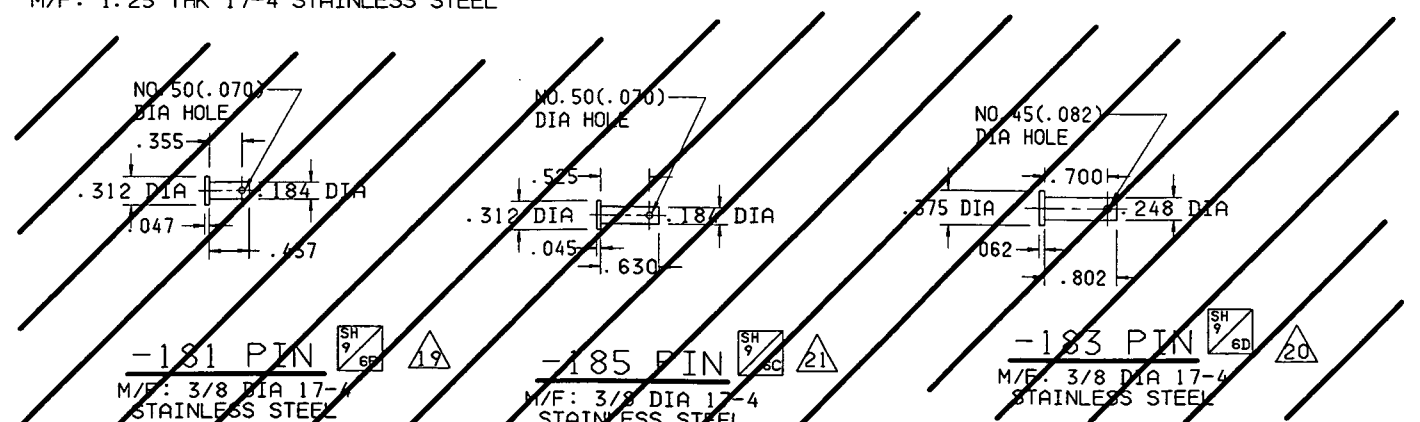
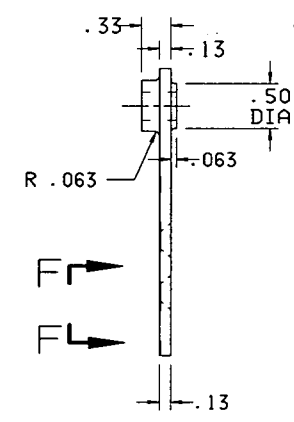
-187 SPACER
(SCALE: 2/1)
M/F: 11/16 DIA ROD
4130 STEEL MIL-S-6758



-105 BRKT (SHOWN)
-106 BRKT (OPP)
M/F: 1.25 THK 17-4 STAINLESS STEEL



-109 BRKT (SHOWN)
-110 BRKT (OPP)
MATL: 1.25 THK 17-4 STAINLESS STEEL



-181 PIN
M/F: 3/8 DIA 17-4
STAINLESS STEEL

-185 PIN
M/F: 3/8 DIA 17-4
STAINLESS STEEL

-183 PIN
M/F: 3/8 DIA 17-4
STAINLESS STEEL

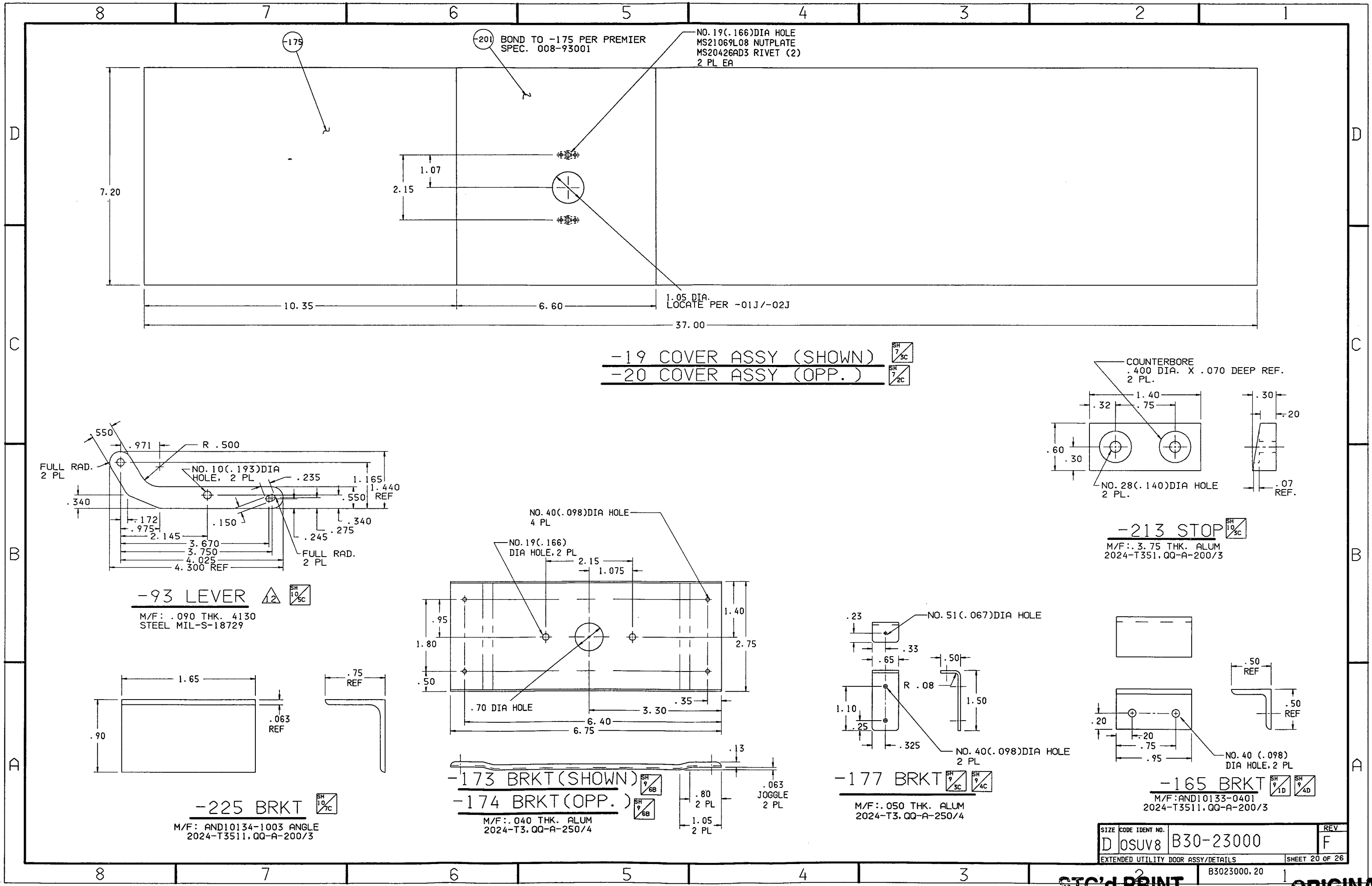
SIZE	CODE	IDENT NO.	REV
D	OSUV8	B30-23000	F
EXTENDED UTILITY DOOR ASSY/DETAILS			SHEET 18 OF 26

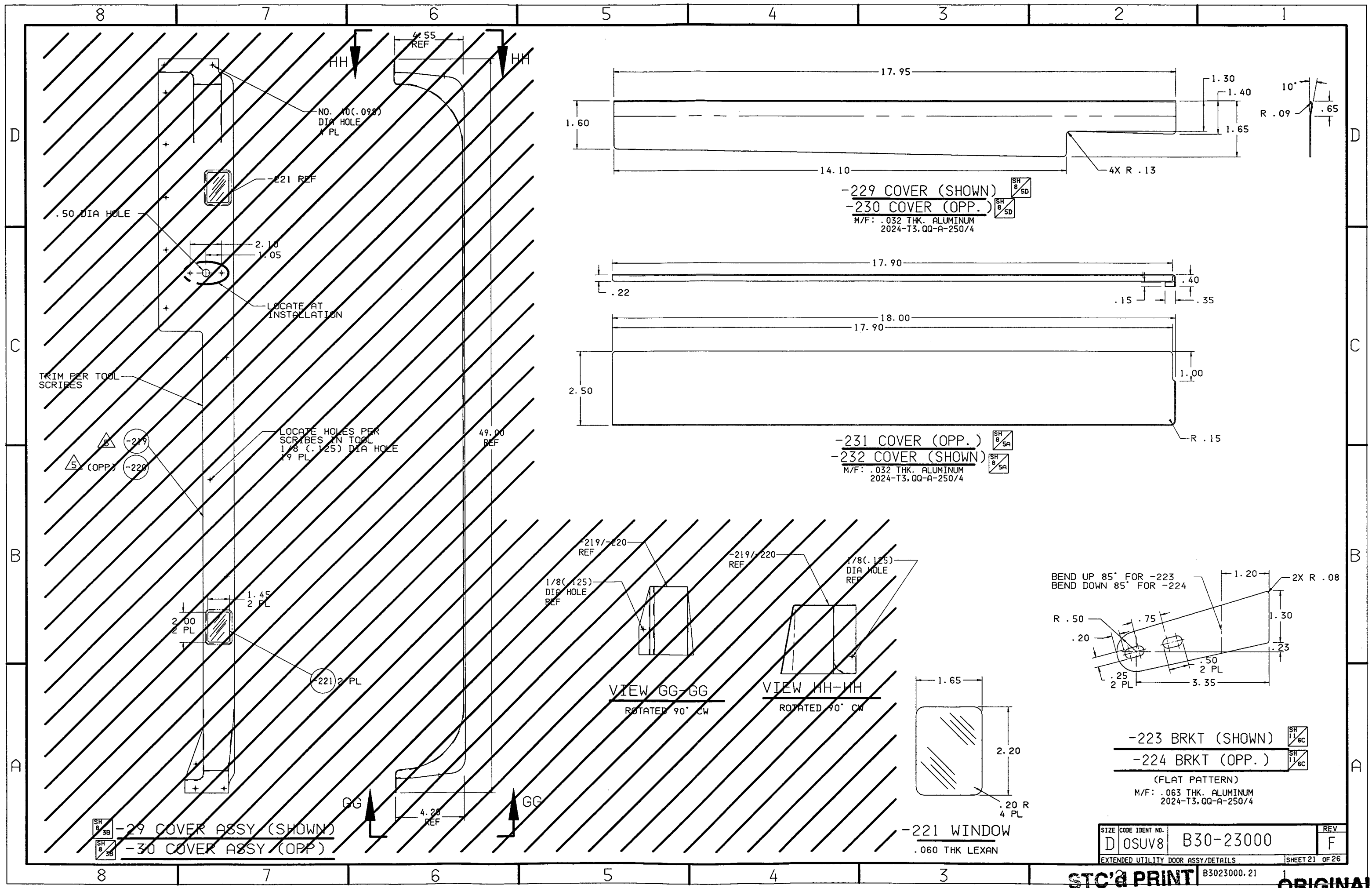
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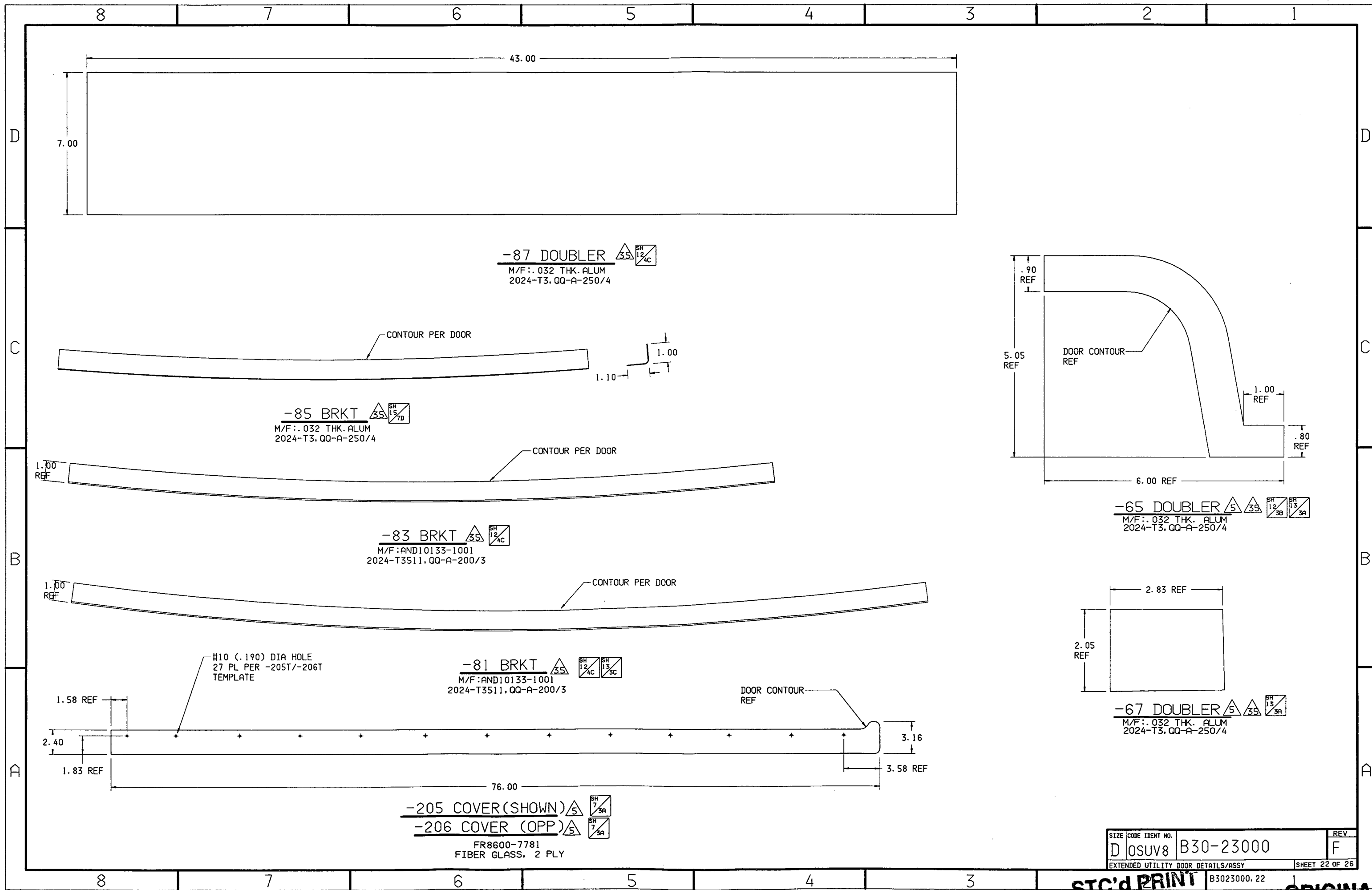
B3023000.18

ORIGINAL

STC SH 8 6 2 5 S W



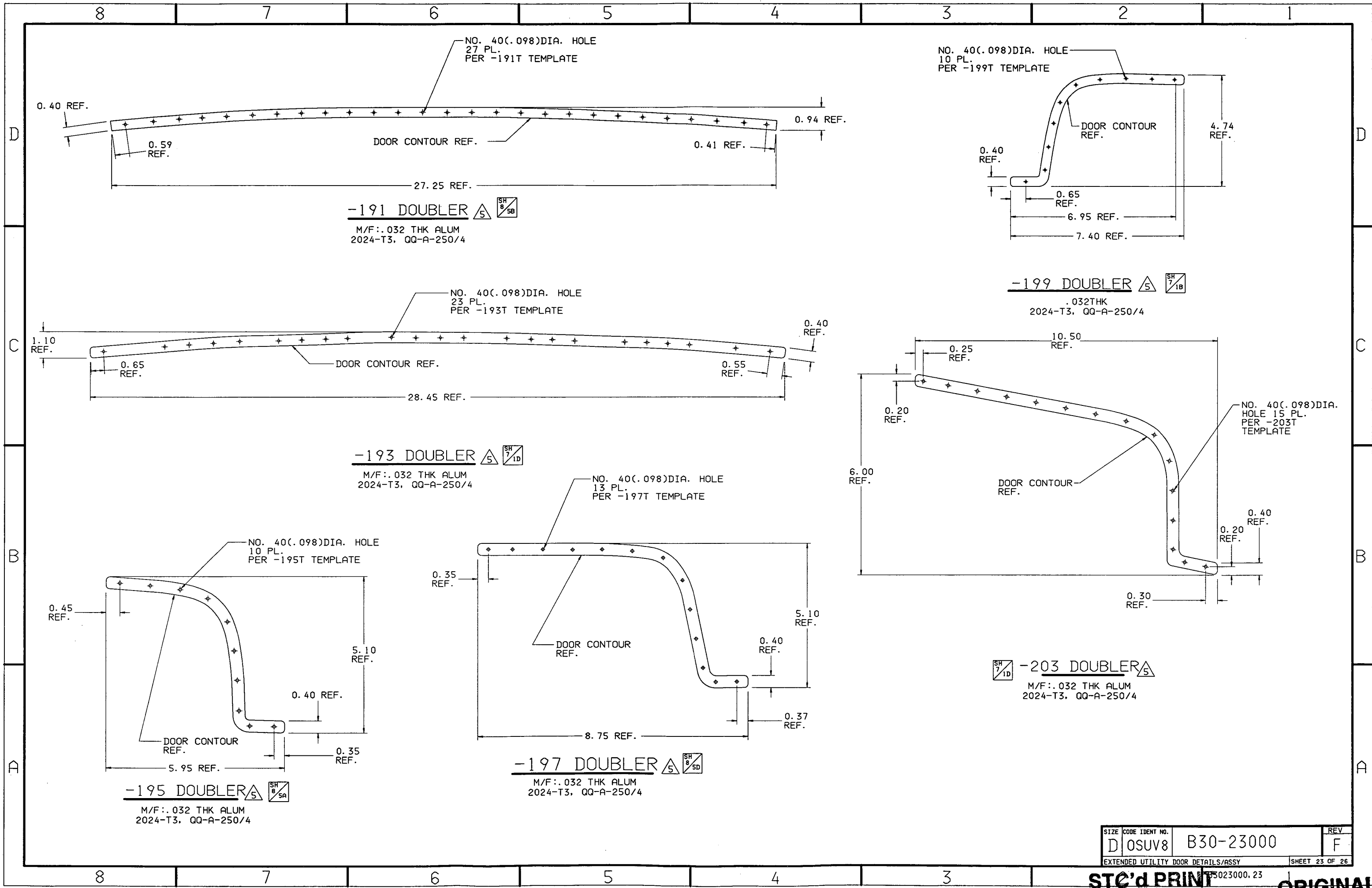




SIZE	CODE	IDENT NO.	REV
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EXTENDED UTILITY DOOR DETAILS/ASSY			SHEET 22 OF 26

STC'd PRINT B3023000.22 ORIGINAL

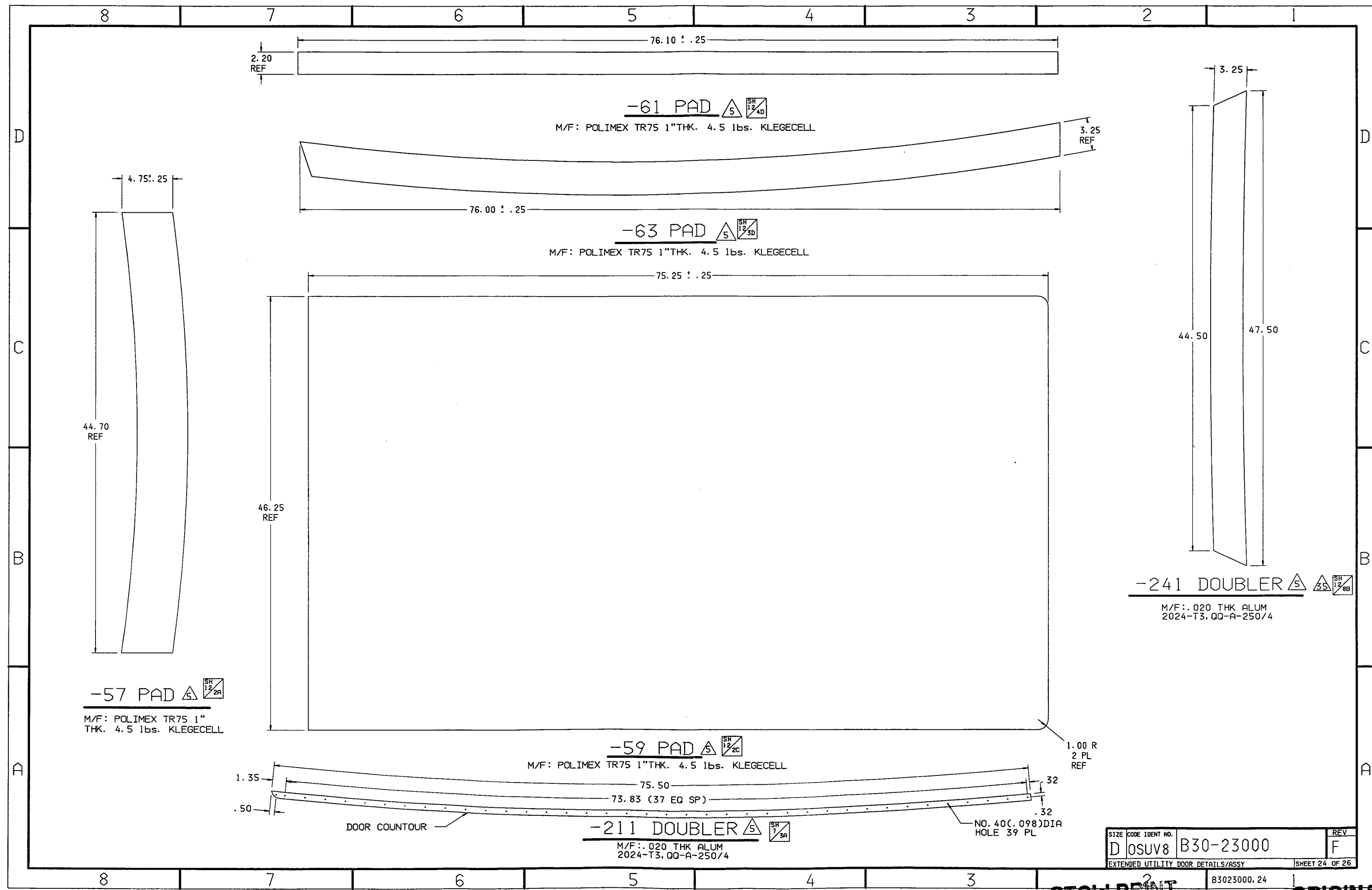
STC SH 8 6 2 5 SW



SIZE	CODE	IDENT NO.	REV
D	OSUV8	B30-23000	F
EXTENDED UTILITY DOOR DETAILS/ASSY			SHEET 23 OF 26

STE'd PRINT ORIGINAL

MS 5298MS41S



SIZE	CODE IDENT NO.	REV
D	OSUV8 B30-23000	F
EXTENDED UTILITY DOOR DETAILS/ASSY		SHEET 24 OF 26

STCSH 625 SW

8

7

6

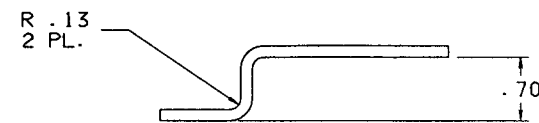
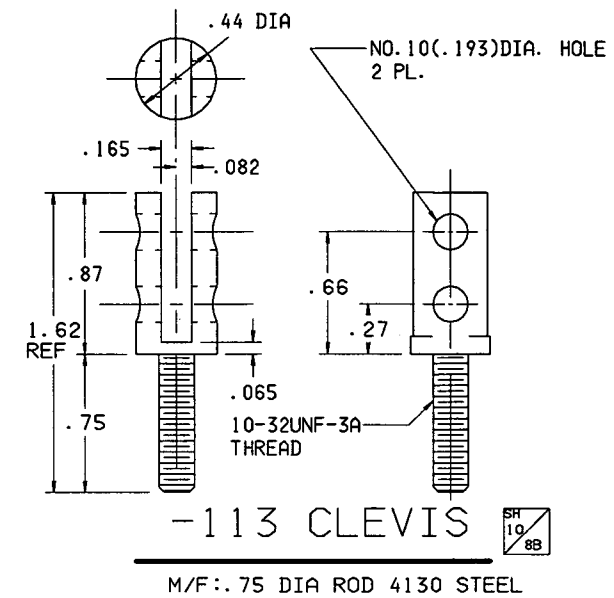
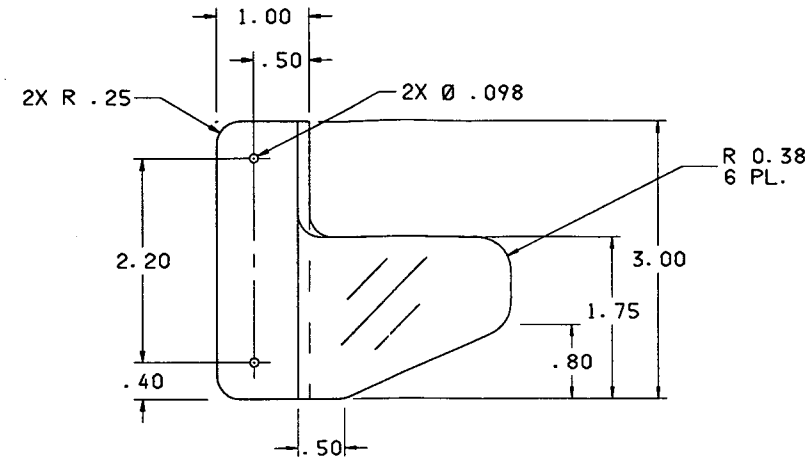
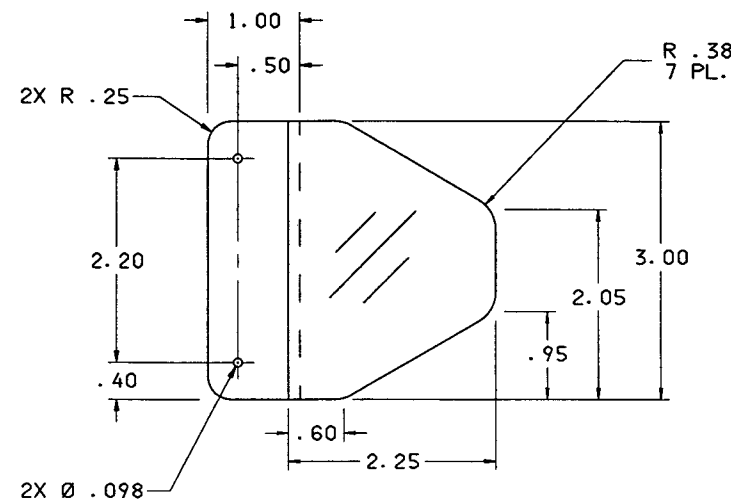
5

4

3

2

1



-237 GUARD (SHOWN)

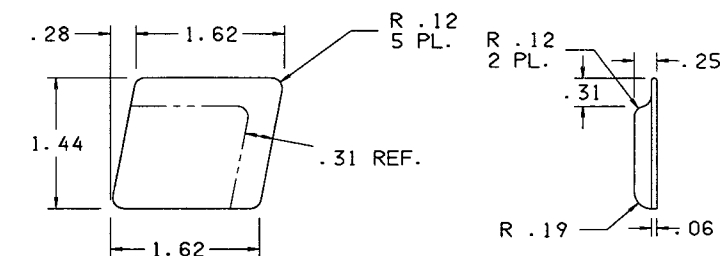
-238 GUARD (OPP.)

MAT'L.: .125 ^{+10%}/_{-50%} THK LEXAN

-239 GUARD (SHOWN)

-240 GUARD (OPP.)

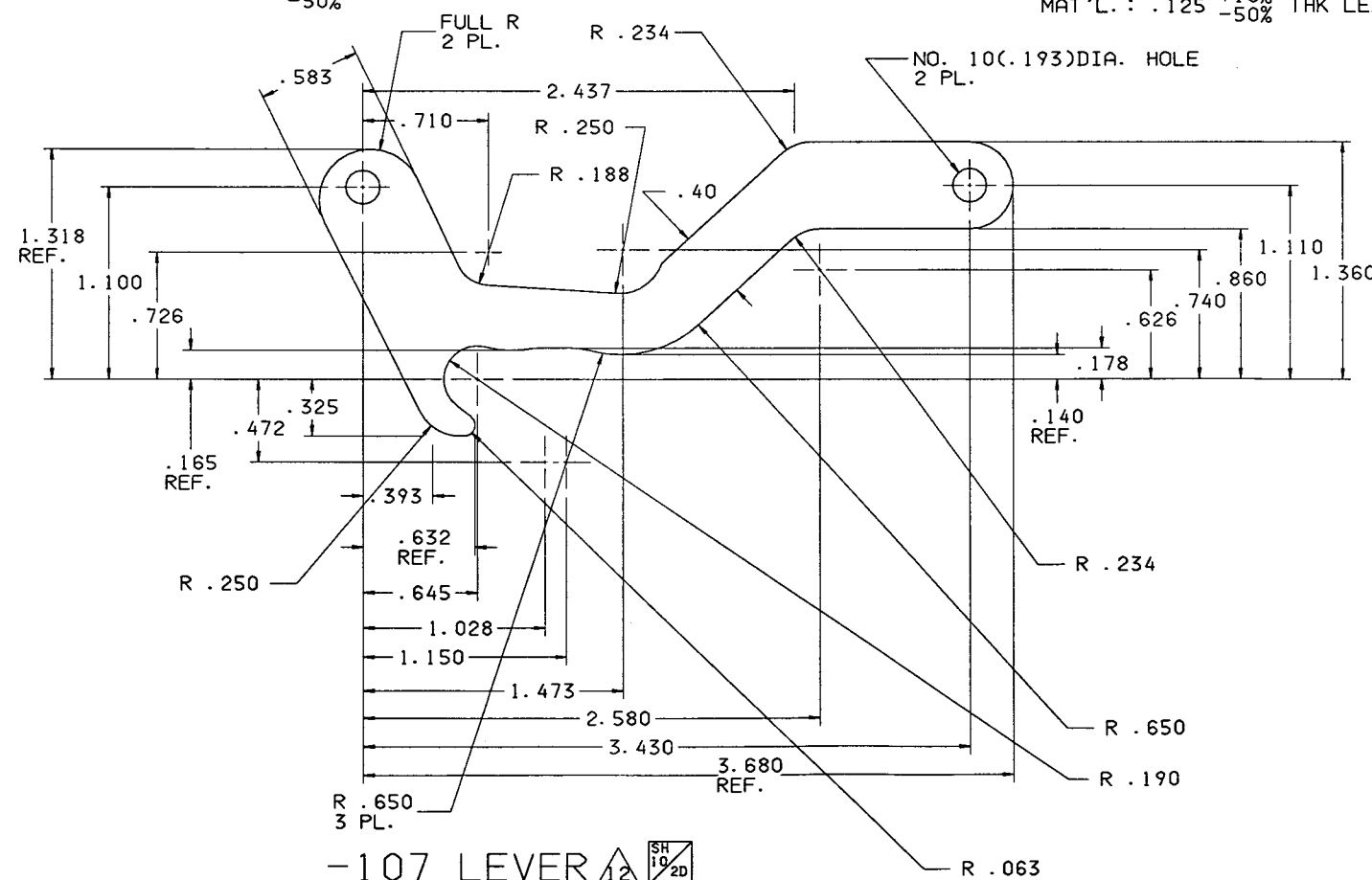
MAT'L.: .125 ^{+10%}/_{-50%} THK LEXAN



-243 SEAL (SHOWN)

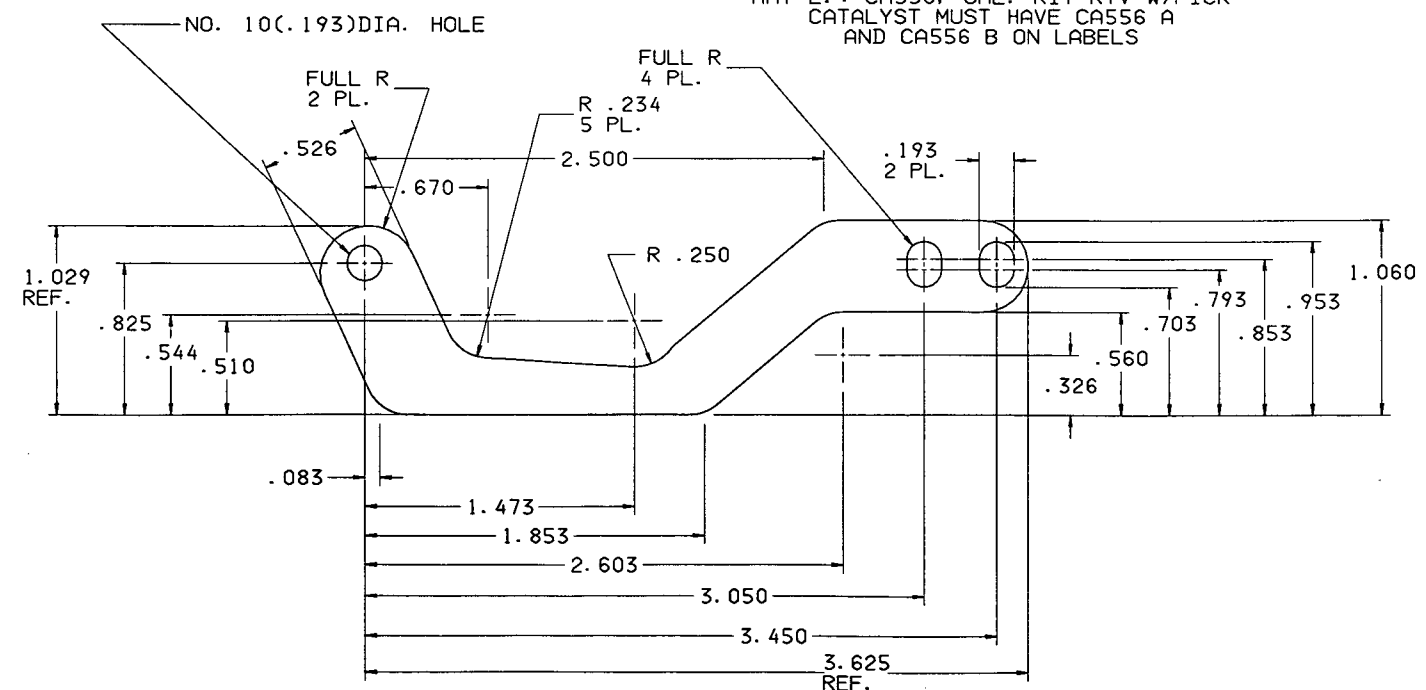
-244 SEAL (OPP.)

MAT'L.: CA556, GAL. KIT RTV W/PICK
CATALYST MUST HAVE CA556 A
AND CA556 B ON LABELS



-107 LEVER

M/F: .090 THK. 4130
STEEL MIL-S-18729



-103 LEVER

M/F: .090 THK. 4130
STEEL MIL-S-18729

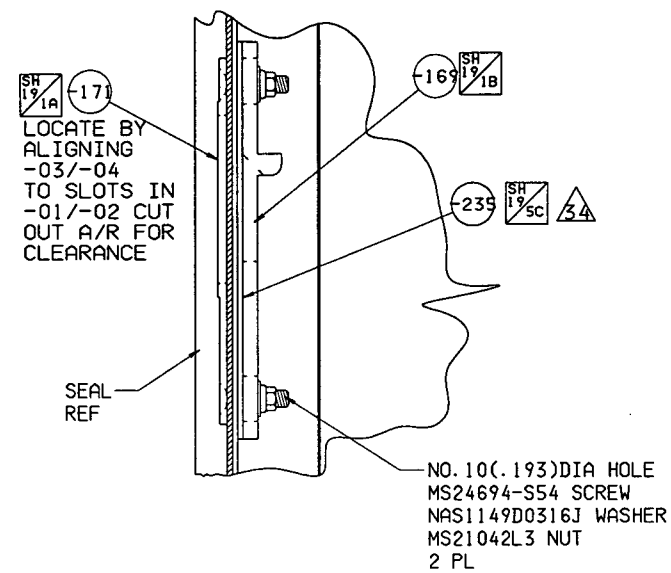
SIZE	CODE	IDENT NO.	REV
D	OSUV8	B30-23000	F
EXTENDED UTILITY DOOR DETAILS/ASSY			SHEET 25 OF 26

STC'd PRINT

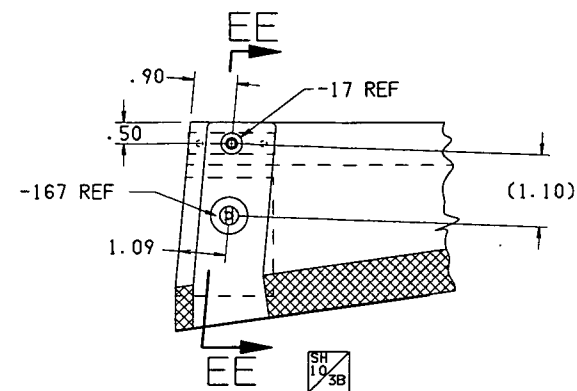
B3023000, 25

ORIGINAL

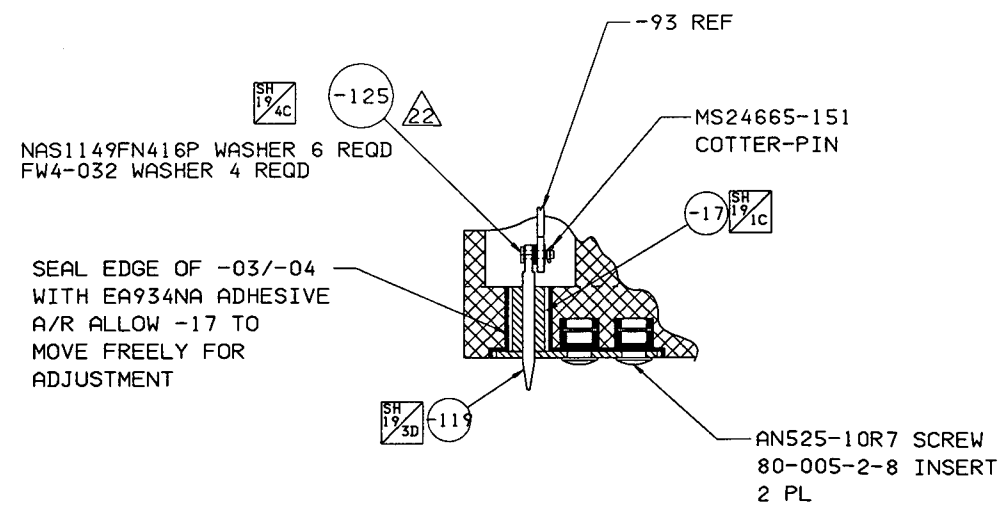
MS 5 2 9 H 301



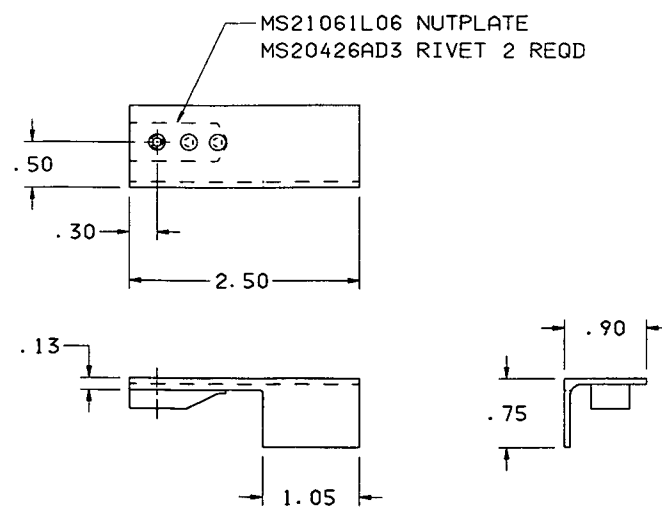
VIEW CC



SECTION Y-Y
-117 BRKT NOT SHOWN FOR CLARITY



SECTION Z-Z



-259 BRACKET
-260 BRACKET (OPP)

MATL: AND10134-1003
2024-T3511 PER QQ-A-200/3

PREMIER AVIATION, INC.			
2621 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE IDENT NO.	DWG NO.	REV.
D	OSUV8	B30-23000	F
SCALE: 1/1		WT:	SHEET 26 OF 26